

**\*77676\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 16/12/2011      **Start Qty:** 6.00

\*6\*

**Cust Item ID:**

**Required Date:** 22/12/2011      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.S Date: 11/12/16

**Tooling:**

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3826	Rev B

0.00

**\*100\***

## Large Fab

## Large Fab

## Memo

0.00

## Large Fab

1- assemble D2325 support gusset together

2- locate D2325 on rib and weld as per dwg D3826

A/R ER316 S.S. Rod Batch: 4115778

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77676

**\*77676\***

Page 2

December-16-11 11:09:59 AM

Item ID: D3826-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib / Gusset Assembly  
 Start Date: 16/12/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 22/12/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>	<i>Basket cell</i>	0.00							
Packaging	Memo								
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>		0.00							
QC	Memo								
Quality Control									

*12.01.22 (8x)*

*12/1/30*

*MF 1201-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December-16-11 11:10:03 AM

Page 1

Work Order ID: 77676

\*77676\*

Parent Item: D3826-041

\*D3826-041\*

Parent Item Name: Rib / Gusset Assembly

Start Date: 16/12/2011

Required Date: 22/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1		Manufactured	No			100	Each	12.0000	1	6			

\*D2235-1\*

Basket Rib

\*\*

B77518 → 5x

Location	Loc Qty	Loc Code
WA	8	
77230	8	
WA005	4	
66895	4	

12.01.21

3x

D3929-041

Manufactured No

100

Each

3.0000

1

6

\*D3929-041\*

Gusset Assembly

\*\*

B77675 → 5x

Location	Loc Qty	Loc Code
WA005	3	
74997	3	

12.01.21

3x

D3929-042

Manufactured No

100

Each

4.0000

1

6

\*D3929-042\*

Gusset Assembly

\*\*

B77677 → 4x

Location	Loc Qty	Loc Code
WA005	4	
74996	4	

12.01.21

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

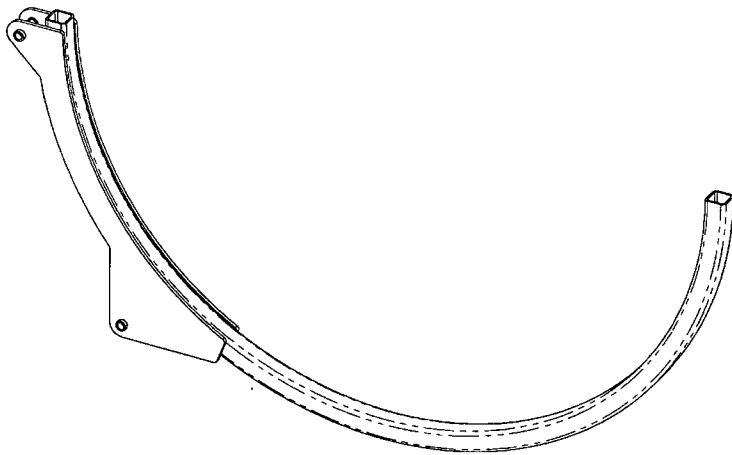
3

2

1

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

B



D3826-041 RIB/GUSSET ASSY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 77676 M.C.J

11/12/16

RELEASED  
9/24/12

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.32 lbs

B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	16		
DRAWN	15		
CHECKED	14		
MFG. APPR.	13		
APPROVED	12		
DE APPR.	11		
DATE	09.04.16		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3826  
TITLE RIB/GUSSET ASSY  
REV. B  
SHEET 1 OF 2  
SCALE NTS

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8

7

6

5

4

3

2

1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

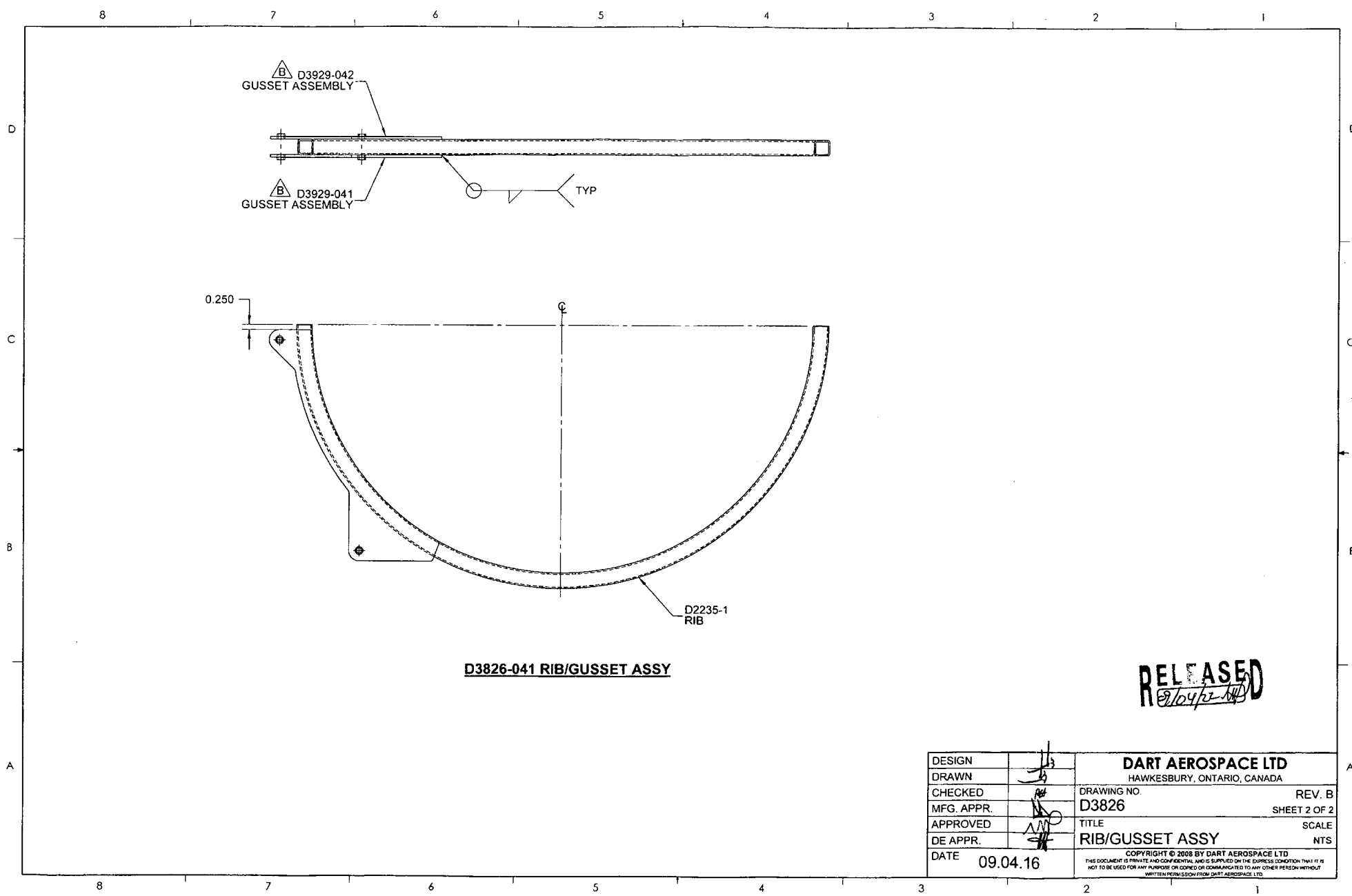
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**NOTE:** Date & initial all entries



77676



**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
9/24/16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3826</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB/GUSSET ASSY</b>	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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